

Date: Monday, 4/30/2007 7:20:48 AM  
User: Kim Johnston

**Process Sheet**

|  |                                      |
|--|--------------------------------------|
| Customer : CU-DAR001 Dart Helicopters Services   | Drawing Name : SKID TUBE ASSEMBLY    |
| Job Number : 32092A  |                                      |
| Estimate Number : 10023  |                                      |
| P.O. Number : <b>NIA</b>   | Part Number : D205634041             |
| This Issue : 4/30/2007 S.O. No. : <b>NIA</b>   | Drawing Number : D2580 REV C         |
| Prsht Rev. : NC  | Project Number : N/A                 |
| First Issue : <b>NIA</b> Type : LANDING GEAR   | Drawing Revision : C                 |
| Previous Run : 32091A  | Material : <b>NIA</b>                |
| Written By : _____   | Due Date : 5/20/2007 Qty: 1 Um: Each |
| Checked & Approved By : <u><b>JA 07.04.30</b></u>  |                                      |
| Comment : Est Rev: N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ<br>Est Rev. O 06.02.28 Added paperwork EC |                                      |

**Additional Product**

Job Number:



|         |                       |               |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

|     |    |                  |
|-----|----|------------------|
| 1.0 | DC | DOCUMENT CONTROL |
|-----|----|------------------|



Comment: DOCUMENT CONTROL

Photocopy D205-634 bluefile & type labels per PPP D205-634 CHG001

**NIA** Packaged with B32092

|     |           |                        |
|-----|-----------|------------------------|
| 2.0 | D25001190 | Ext'n -1" Beam Tube 4" |
|-----|-----------|------------------------|



Comment: Qty.: 1.0400 Each(s)/Unit Total : 1.0400 Each(s)

Pick:

|                 |                     |                |
|-----------------|---------------------|----------------|
| Qty Part Number | Description         | Batch          |
| 1 D2500-1-190   | Skid Tube Extrusion | <b>B 29602</b> |

**JB 7-5-3**

|     |       |         |
|-----|-------|---------|
| 3.0 | D2596 | 205 Web |
|-----|-------|---------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

|                 |             |                |
|-----------------|-------------|----------------|
| Qty Part Number | Description | Batch          |
| 1 D2596         | 205 Web     | <b>B 32098</b> |

**JB 7-5-18**

|     |                |                         |
|-----|----------------|-------------------------|
| 4.0 | LANDING GEAR 1 | LANDING GEAR RESOURCE 1 |
|-----|----------------|-------------------------|



Comment: LANDING GEAR RESOURCE 1

- 1- Inspect mat'l D2500-1-190 for damage
- 2-Cut D2500-1-190 per Dwg D2580 if necessary Deburr ends
- 3-Acid etch and Alodine tube per QSI 005 4.1
- 4-Drill pilot holes using drill jig DT 8149(Do not use cutting fluid)

**JB 7-5-3**

| W/O: |      | WORK ORDER CHANGES |  |    |      |     |                                     |                          |
|------|------|--------------------|--|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   |  | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |  |    |      |     |                                     |                          |
|      |      |                    |  |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                      |                                 |           |                |                           |                       |                          |
|------|------|----------------------------------|----------------------|---------------------------------|-----------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action    |                                 | Section B |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng | Action Description<br>Chief Eng |           | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                      |                                 |           |                |                           |                       |                          |
|      |      |                                  |                      |                                 |           |                |                           |                       |                          |
|      |      |                                  |                      |                                 |           |                |                           |                       |                          |

NOTE: Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKID TUBE ASSEMBLY

Job Number: 32092A

Part Number: D205634041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5-Open holes to 0.500" as per Dwg D2580 without cutting fluid

6-Countersink holes as per Dwg D2580 without cutting fluid

7-Deburr and blow out all chips from inside of tube

8-Bond web in place per QSI 015. Allow 12 Hrs. cure time before cutting

Pick:

Qty Part Number Description Batch

A/R Sikaflex-291 *m103561*

Sikaflex expire date: *7-10-1*

Start Time: *8:35* Date: *7-5-18*

Fin Time: *8:30* Date: *7-5-18*

*JD 7-5-3*

*JD 7-5-18*

5.0

BENDING

BENDING MACHINE



Comment: BENDING MACHINE

1-Bend as per program D2580.C on CNC Bender and Folio FT009

2-Cut tubes as per Dwg. D2580

*PL 7-5-24*

6.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Deburr ends after cutting. Remove alodine from around holes

*JD 7-6-4*

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*BE 07-06-05*

8.0

D25763

Step (Machining Detail)



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch  
1 D2576-3 Step *B29486*

*BE 07-06-05*

9.0

D2579

Crossbolt Spacer



Comment: Qty.: 20.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:

Qty Part Number Description Batch

| W/O: |      | WORK ORDER CHANGES |  |    |      |     |                                     |                          |  |
|------|------|--------------------|--|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE   |  | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |  |
|      |      |                    |  |    |      |     |                                     |                          |  |
|      |      |                    |  |    |      |     |                                     |                          |  |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                                |                                 |                |                           |                       |                          |  |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|--|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action<br>Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |  |
|      |      |                                  | Initial<br>Chief Eng           | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |  |
|      |      |                                  |                                |                                 |                |                           |                       |                          |  |
|      |      |                                  |                                |                                 |                |                           |                       |                          |  |
|      |      |                                  |                                |                                 |                |                           |                       |                          |  |

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Drawing Name: SKID TUBE ASSEMBLY

Job Number: 32092A

Part Number: D205634041

Job Number:



Seq. #:

Machine Or Operation:

Description:

20

D2579

Spacers

B 31108

BE 07-06-05

10.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Prepare tube for welding D2576-3 Step Remove alodine as required.

BE 07-06-05

2-Weld step D2576 as per Dwg. D2580 and QSI 004

A/R

Aluminum Rod

m103794

BE 07-06-05

3-Weld crossbolt spacers D2579 as per Dwg. D2580 and QSI 004

For D2579 spacers, weld one side, pass 3/8" drill, weld other side, pass 3/8" drill

A/R

Aluminum Rod

m103794

BE 07-06-05

4-Grind welds as per Dwg D2580 Grind flush ridge made from bending

R 107-6-7

5-Drill holes for wearplates using DT 8217 Open holes to 19/64", adjust stopper not to hit web. Deburr

m 07-06-11 (1)

6-Counterbore crossbolt spacers to 7/16" ID x 1.0" deep as per Dwg D2580. Deburr holes

m 07-06-11 (1)

7-Drill pilot holes for aft cap using DT 8215 Open holes to #6 Drill bit. Deburr

m 07-06-11 (1)

8-Drill pilot holes for Tow ring using DT8091, open to .640" and Deburr

m 07-06-11 (1)

11.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

107/06/11 (1)

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

107-06-19 (1)

13.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Pressure wash as per QSI 005

107-06-19 (1)

| W/O: |      | WORK ORDER CHANGES |  |    |      |     |                                     |                          |
|------|------|--------------------|--|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   |  | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |  |    |      |     |                                     |                          |
|      |      |                    |  |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                      |                                 |           |                |                           |                       |                          |
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| DATE | STEP | Description of NC<br>Section A   | Corrective Action    |                                 | Section B |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng | Action Description<br>Chief Eng |           | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                      |                                 |           |                |                           |                       |                          |
|      |      |                                  |                      |                                 |           |                |                           |                       |                          |
|      |      |                                  |                      |                                 |           |                |                           |                       |                          |

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Drawing Name: SKID TUBE ASSEMBLY

Job Number: 32092A

Part Number: D205634041

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

POWDER COATING

POWDER COATING



WHITE M/104144



①

Comment: POWDER COATING

~~POWDER COATING~~  
Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

BR/FL 07-06-20

15.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M/L 07/06/20

16.0

D25771

Wearplate Fwd



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

| Qty | Part Number | Description |
|-----|-------------|-------------|
| 1   | D2577-1     | Wearplate   |

Batch

B29994

17.0

D25773

Wearplate Aft



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

| Qty | Part Number | Description |
|-----|-------------|-------------|
| 1   | D2577-3     | Wearplate   |

Batch

B30551

18.0

D25775

Wearplate, Centre



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

| Qty | Part Number | Description |
|-----|-------------|-------------|
| 1   | D2577-5     | Wearplate   |

Batch

B31254

19.0

ALS71032130

Insert



Comment: Qty.: 44.0000 Each(s)/Unit Total : 44.0000 Each(s)

Pick:

| Qty | Part Number   | Description |
|-----|---------------|-------------|
| 44  | ALS7-1032-130 | Inserts     |

Batch

M/03495

FL 07/06/20 ①



| W/O: |      | WORK ORDER CHANGES |  |    |      |     |                                     |                          |  |
|------|------|--------------------|--|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE   |  | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |  |
|      |      |                    |  |    |      |     |                                     |                          |  |
|      |      |                    |  |    |      |     |                                     |                          |  |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                      |                                 |                |                           |                       |                          |  |
|------|------|----------------------------------|----------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|--|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action    |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |  |
|      |      |                                  | Initial<br>Chief Eng | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |  |
|      |      |                                  |                      |                                 |                |                           |                       |                          |  |
|      |      |                                  |                      |                                 |                |                           |                       |                          |  |
|      |      |                                  |                      |                                 |                |                           |                       |                          |  |

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Drawing Name: SKID TUBE ASSEMBLY

Job Number: 32092A

Part Number: D205634041

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

AN960JD10L

Washer



Comment: Qty.: 44.0000 Each(s)/Unit Total : 44.0000 Each(s)

Pick:

| Qty | Part Number | Description | Batch   |
|-----|-------------|-------------|---------|
| 4 4 | AN960JD10L  | Washer      | m103641 |

21.0

AN34A

Bolt



Comment: Qty.: 44.0000 Each(s)/Unit Total : 44.0000 Each(s)

Pick:

| Qty | Part Number | Description | Batch   |
|-----|-------------|-------------|---------|
| 44  | AN3-4A      | Bolt        | m103481 |

22.0

D25941

Plug



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

plug

Batch: m30140

23.0

D25943

O-Ring



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

o-ring

Batch: m27168

24.0

D2855

Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Cap

Batch: B27488

25.0

AN35A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch: m15205

FeL 07/06/20 ①

| W/O: |      | WORK ORDER CHANGES |  |    |      |     |                                     |                          |  |
|------|------|--------------------|--|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE   |  | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |  |
|      |      |                    |  |    |      |     |                                     |                          |  |
|      |      |                    |  |    |      |     |                                     |                          |  |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: 1 Date: 5/18/06  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                      |                                 |           |                |                           |                       |                          |
|------|------|----------------------------------|----------------------|---------------------------------|-----------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action    |                                 | Section B |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng | Action Description<br>Chief Eng |           | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                      |                                 |           |                |                           |                       |                          |
|      |      |                                  |                      |                                 |           |                |                           |                       |                          |
|      |      |                                  |                      |                                 |           |                |                           |                       |                          |

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Drawing Name: SKID TUBE ASSEMBLY

Job Number: 32092A

Part Number: D205634041

Job Number:



Seq. #:

Machine Or Operation:

Description:

26.0

AN960JD10L

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Washer

Batch: m/103641

27.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Install inserts & wearplates as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates

A/R Sikaflex-291 m/104732

Sikaflex expire date: 07/10

2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580

3-Inspect for foreign object per QSI 024

4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with Sikaflex. Clean excess adhesive

A/R Sikaflex-291 m/104732

Sikaflex expire date: 07/10

5-Wing Walk as per Dwg D2580 and QSI 005 4.4

m/104733

FL

Batch: 07/06/21 ①

FL  
07/06/20 ①

28.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

29.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D205-634-041

Location: \_\_\_\_\_

PPP Rev: \_\_\_\_\_

PPP 32092

07/06/250

30.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/06/206 ①

Job Completion



07/06/26

| W/O: |      | WORK ORDER CHANGES |  |    |      |     |                                     |                          |  |
|------|------|--------------------|--|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE   |  | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |  |
|      |      |                    |  |    |      |     |                                     |                          |  |
|      |      |                    |  |    |      |     |                                     |                          |  |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                      |                                 |                |  |                           |                       |                          |
|------|------|----------------------------------|----------------------|---------------------------------|----------------|--|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action    |                                 | Section B      |  | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng | Action Description<br>Chief Eng | Sign &<br>Date |  |                           |                       |                          |
|      |      |                                  |                      |                                 |                |  |                           |                       |                          |
|      |      |                                  |                      |                                 |                |  |                           |                       |                          |
|      |      |                                  |                      |                                 |                |  |                           |                       |                          |

**NOTE:** Date & initial all entries



|                               |                                |   |                        |
|-------------------------------|--------------------------------|---|------------------------|
| DESIGN<br><i>[Signature]</i>  | DRAWN BY<br><i>[Signature]</i> | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |                        |
| CHECKED<br><i>[Signature]</i> | APPROVED<br><i>[Signature]</i> | DRAWING NO.<br>D2580                              | REV. C<br>SHEET 1 OF 2 |
| DATE<br>98.08.26              |                                | TITLE<br>205 SKIDTUBE ASSEMBLY                    | SCALE<br>NTS           |
| A                             | 96.09.16                       | NEW ISSUE   |                        |
| B                             | 96.12.02                       | AS MANUFACTURED                                   |                        |
| C                             | 98.08.26                       | REDRAWN, INCLUDED DEO 9094/9097                   |                        |

RELEASED  
98/09/17 DS

| QTY | Part Number   | Description       |
|-----|---|-------------------|
| X   | D2580-041   | SKIDTUBE ASSEMBLY |
| *   | D2500-1   | EXTRUSION         |
| 1   | D2596   | 205 WEB           |
| 1   | D2575   | AFT CAP           |
| 1   | D2576 - 3   | STEP              |
| 20  | D2579   | CROSS BOLT SPACER |
| 16  | D2594-1   | PLUG              |
| 16  | D2594-3   | O-RING            |
| 1   | D2577-1   | WEARSHOE          |
| 1   | D2577-3   | WEARSHOE          |
| 1   | D2577-5   | WEARSHOE          |
| 44  | ALS7-1032-130<br>or AKS7-1032-130<br>or AKS4-1032-130<br>or ALS4-1032-130 | INSERT            |
| 46  | AN3-4A  | BOLT              |
| 46  | AN960JD10L  | WASHER            |

# 00 08.28  
UP 00.08.28

EFFECTIVE DEOs  
98/12/14  
DEO 9124  
DEO 9183

#### GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) LENGTH OF D2500-1 EXTRUSION BEFORE BENDING = 190 INCHES \*
- 3) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) USE DART DRILL TEMPLATE TD2577-205 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (44 PLACES) AFTER FINISH. INSTALL AN3-4A BOLTS AND AN960JD10L WASHERS WITH SIKAFLEX-241.
- 6) WELDING TO BE DONE PER DART QSI 004.
- 7) FINISH:  
ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB  
POWDER COAT ASSEMBLY GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
- 8) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES).

Diagram of a circular cross-section of a pipe with four vertical stiffeners. The stiffeners are spaced 3.500 units apart. The distance from the centerline to the outer edge of the stiffeners is 1.750 units.

DETAIL B  
SCALE 5:24

#00 08.78  
UP 08.28.28

D2576-3

GRIND FLUSH (4 PLACES)

GRIND FLUSH

STEP

GRIND FLUSH

LOCATION RIDGE ON UNDERSIDE OF D2576

X

Technical drawing of a bolted cap assembly. The drawing shows a cross-section of a cap being bolted to a structure. The following components and dimensions are labeled:

- DRILL PRIOR TO D2575 CAP INSTALLATION (2 PLACES)**: Points to the pre-drilled holes in the cap.
- SEAL WITH SIKAFLEX-241**: Points to the sealant applied around the cap.
- AN3-4A BOLT (1)**: Points to the bolt used to secure the cap.
- AN96QD10L WASHER (1)**: Points to the washer used under the bolt head.
- (2 PLACES)**: Indicates the bolt and washer are used at two locations.
- D2575 CAP**: Points to the cap being installed.
- Ø40**: Dimension indicating the diameter of the cap.

D2579 SPACER

WEB (REF)

.130 (REF)  
4 PLACES

AFTER PERFORMING  
1. CHA  
2. INS  
3. WE  
4. C'B

AFTER DRILLING AND BENDING ASSEMBLY  
PERFORM THE FOLLOWING FOR #0.508 HOLES ONLY:

1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2579 SPACER (20 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. C'BORE D2579 SPACER TO  $\phi 0.437$  X 1.00 DEEP

37.50  
DISTANCE TO AFT END  
OF D2596 WEB  
3 7  
1.750 1.750  
#508 (TYP.)  
(40 PLACES)  
REFER TO DETAIL A  
8.750  
17.375  
26.000  
34.188  
57.313 (REF)  
7 EQUAL SPACES  
8.188 PITCH  
38.0  
91.500  
190.0  
(D2500-1)  
REFER TO DETAIL A

WELD AS PER DETAIL 8

BLACK ANTI-SKID TOP OF STEP TO 0.5 ABOVE BOTTOM EDGE

0.5 1.5 1.5 D

BLACK ANTI-SKID TO 0.5 ABOVE LOCATION RIDGE

1.5 1.5 1.5

P P P P P P P P

REFER TO DETAIL C

D2577-3

8

D2577-5

D2577-1

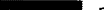
AN3-4A BOLT (1)  
AN960JD10L WASHER (1)  
(44 PLACES)

DESIGN *DAH*

DRAWN BY *CB*

**DART**

RELEASED  
98/09/17 DS

|                       |                                |  |
|-----------------------|--------------------------------|--|
| DESIGN<br><i>DBH</i>  | DRAWN BY<br><i>CP</i>          |  <b>DART AEROSPACE LTD</b><br>HARRISBURY, ONTARIO, CANADA |
| CHECKED<br><i>DBH</i> | APPROVED<br><i>JS</i>          |  |
| DATE<br>98.08.26      | DRAWING NO.<br>D2580           | REV. C<br>SHEET 2 OF 2   |
|                       | TITLE<br>205 SKIDTUBE ASSEMBLY | SCALE<br>1:24  |

NO. 118

AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name Baachy Elliott  
Joint Welding Procedure Tig  
Part number and Job number A205634041 / B31973

TEST WELDS REQUIRED

BASE METAL Alum WELDING PROCESS Tig  
Penetration Complete ☐ Partial ☒ Single Weld ☒ Double Weld ☐  
Current AC ☒ DC ☐ Backing YES ☐ NO ☒

|              | Position                    | Vertical                    | Down <input type="checkbox"/> | Up <input type="checkbox"/> |
|--------------|-----------------------------|-----------------------------|-------------------------------|-----------------------------|
| Sheet Groove | 1G <input type="checkbox"/> | 2G <input type="checkbox"/> | 3G <input type="checkbox"/>   | 4G <input type="checkbox"/> |
| Tube Groove  | 1G <input type="checkbox"/> | 2G <input type="checkbox"/> | 5G <input type="checkbox"/>   | 6G <input type="checkbox"/> |
| Sheet Fillet | 1F <input type="checkbox"/> | 2F <input type="checkbox"/> | 3F <input type="checkbox"/>   | 4F <input type="checkbox"/> |
| Tube Fillet  | 1F <input type="checkbox"/> | 2F <input type="checkbox"/> | 4F <input type="checkbox"/>   | 5F <input type="checkbox"/> |

Crossbolt Spacer Welded into Skid tube

TEST RESULTS

Visual Pass ☒ Fail ☐  
Penetration Pass ☒ Fail ☐  
Crossbolt Spacer Pass ☒ Fail ☐

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

Date of Test Coupon 07/06/04 Qualifier David Furel